

Work Order ID 84084

June-01-12 9:25:53 AM

Duplicate

84084

Page 1

Item ID: D3319-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 02/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: *ML*

Date: *12/06/01*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319								
	Dwg Rev: <i>C</i>								
	Prog Rev: <i>C</i>								
	2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10 0 JM 12-5-17

10 0 JM 12-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84084

June-01-12 9:25:54 AM

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Page 2

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N900040100

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Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 02/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

5/21/12

YB

Quality Control

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

9

5/21/12

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: C

150

QC6- Inspect dimensions to drawing

0.00

150

QC

Memo

0.00

5/21/12

XS

Quality Control

W/O: 84084		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3319-3 PAR #: _____ Fault Category: small Fab/water jet NCR: Yes No DQA: Not Date: 12/06/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CL Date: 12/6/07

NCR: 121482		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/23	4 no	Part Faced with extra hole cut in it from water jet. B.C. Part moves down water jet	S Q57042 12/05/23	Scrap + Destroy no Repair.	S 12/05/23	S 12/05/23	S Q57042 12/05/23	S 12/05/23

NOTE: Date & initial all entries

Work Order ID 84084

June-01-12 9:25:54 AM

84084

Page 3

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Accept

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Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 02/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Weld per dwg A/R Hardcoat steel Batch: m121603
Large Fab

160

Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319
Batch A/R 7560 Hardcoat Rod m121603

(X9) me 12-06-01

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

8766601

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

8766601

Quality Control

(X9)

W/O:		WORK ORDER CHANGES					
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Page 4

June-01-12 9:25:54 AM

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Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 02/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Powder Coating

Memo

START TIME:

2:30 0.00

OVEN TEMPERATURE:

3200 F

FINISH TIME:

3:00

200

QC3- Inspect Part Finish

0.00

200

QC

Quality Control

Memo

0.00

210

Packaging

0.00

210

Packaging

Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock

Location: 497

9X ✓ 12/06/04

ev d 12/06/06

944/5 (9)

12/27/12

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 84084***84084***

Page 5

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Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/6/6

H 12-06-5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-01-12 9:25:57 AM

Page 1

Work Order ID: 84084

84084

Parent Item: D3319-3

D3319-3

Parent Item Name: Wearplate

Start Date: 02/05/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	7.0960	3.2524	34.23579			
**													
1010/1025 SHEET .048													

M1010S18GA

Location

Loc Qty

Loc Code

MAT019

7.096

116268

3

117806

4.096

117806

JM
12-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84084
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓		MT	MB-01
74.420	+/-0.010	74.420	✓		MT	MB-01
62.770	+/-0.010	62.770	✓		MT	MB-01
52.890	+/-0.010	52.890	✓		MT	MB-01
30.790	+/-0.010	30.790	✓		MT	MB-01
8.690	+/-0.010	8.698	✓		Vern	Prot-w-joe
0.60	+/-0.030	0.612	✓		Vern	Prot-w-joe MB-02
2.690	+/-0.010	2.701 2.698	✓		Vern	MB-02
2.940	+/-0.010	2.949	✓		Vern	MB-02
3.527	+/-0.010	3.530	✓		Vern	MB-02
4.518	+/-0.010	4.525	✓		Vern	MB-02
Ø0.190	+0.005/-0.001	0.190	✓		Vern	MB-02
2.940	+/-0.010	2.949	✓		Vern	MB-02
2.940	+/-0.010	2.948	✓		Vern	MB-02
2.690	+/-0.010	2.698	✓		Vern	MB-02
5.063	+/-0.010	5.066	✓		Vern	MB-02
6.163	+/-0.010	6.170	✓		Vern	MB-02
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	0.35 x 0.607	✓		Vern	MB-02
0.048	+/-0.010	0.047	✓		Vern	MB-02

Measured by: Jm	Audited by: S	Prototype Approval:	N/A
Date: 12-5-17	Date: 12/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	JE

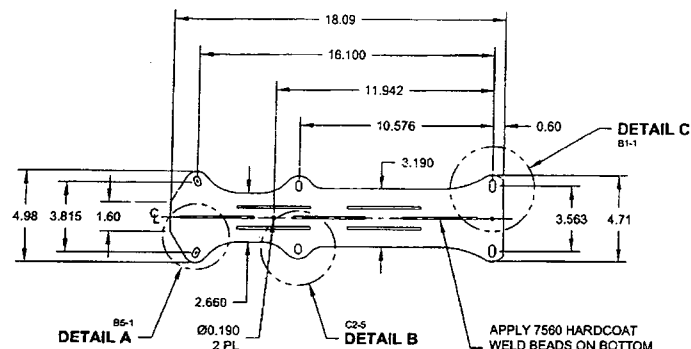
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

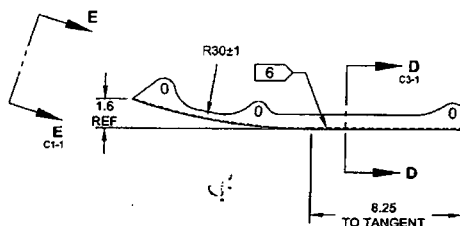
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

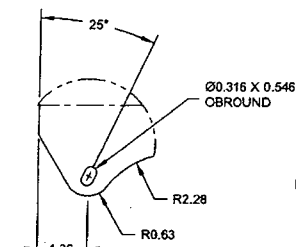
NOTE: Date & initial all entries



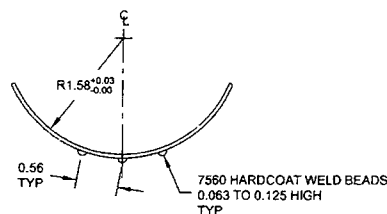
D3319-1F FLAT PATTERN



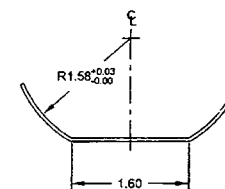
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



SECTION D-D
SCALE 4X

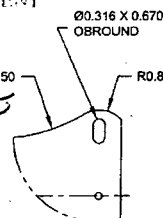


SECTION E-E
SCALE 4X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 24084

12/06/09



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-546 12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3319
SHEET 1 OF 4
TITLE WEARPLATE
SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

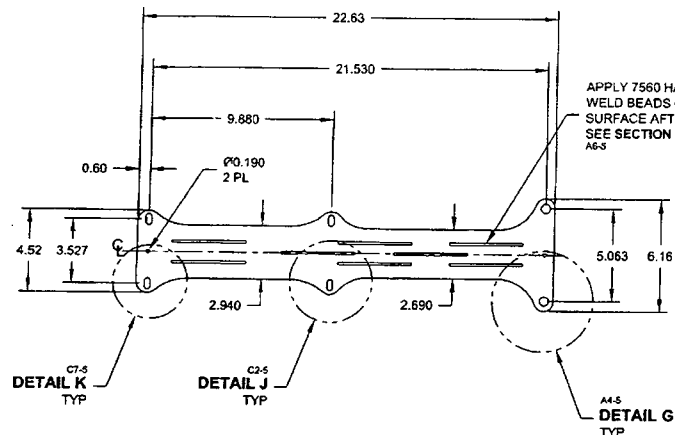
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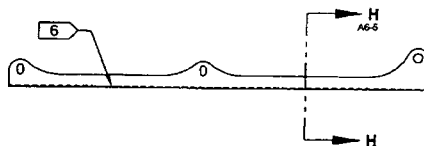
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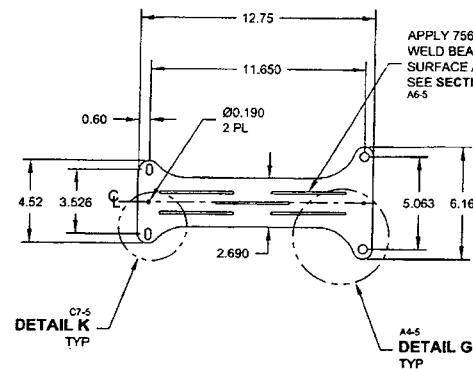
NOTE: Date & initial all entries



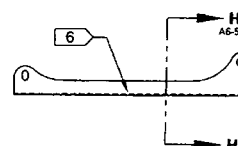
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

D3319-5/-7 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	

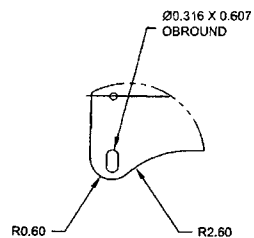
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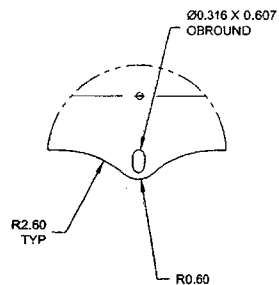
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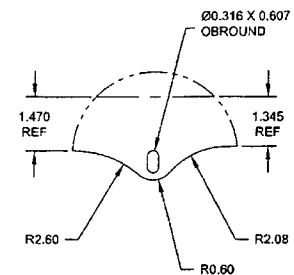
NOTE: Date & initial all entries



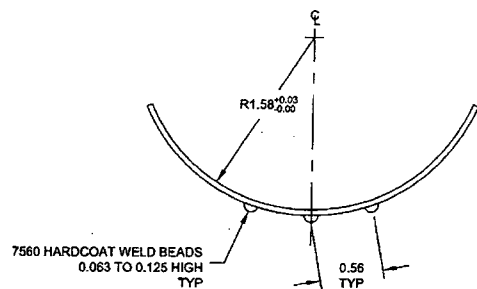
DETAIL K
SCALE 2X
B8-2
C4-3
C9-3



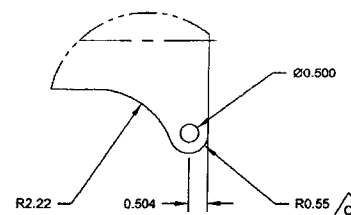
DETAIL F
SCALE 2X
B5-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3
C

RELEASED
2012-02-16
9, 2, 03, 16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO. D3319	REV. C
MFG. APPR.	S		SHEET 4 OF 4
APPROVED	#	TITLE WEARPLATE	SCALE NTS
DE APPR.	#		
DATE	12.03.13		

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